

Date: Friday, 12/12/2008 2:21:36 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 44045					
Estimate Number	: 10256					
P.O. Number	:			Part Number	: D22303	
This Issue	12/12/2008	S.O. No.	:	Drawing Number	: D2230 REV F	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	:/ /	Type	MACHINED PARTS	Drawing Revision	: F	
Previous Run	: 43223			Material	:	
Written By	:			Due Date	: 10/01/2009	
Checked & Approved By	: JDP 08-12-12			Qty:	200	Um: Each
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)

Lug Extrusion

D2423

Batch: B43722



2.0	D22303P	LUG
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~~cut @ metco~~

Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)

LUG



3.0	BAND SAW	BAND SAW
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~~issue P10 metco~~

Comment: Band Saw

R10:7828

c208112115

(200)

Cut D2423 extrusion to 0.82"

Batch:

~~Machine as per drawing. REV. F~~

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

LC 9/01/14 (221)

5.0

~~QC2~~



INSPECT PARTS AS THEY COME OFF MACHINE

~~read + inspect for damage~~

~~attached CofC to w10~~



counter

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S 09/01/14 X201

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/12/2008 2:21:37 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: MOUNTING LUG
Job Number: 44045		Part Number: D22303
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8 	SECOND CHECK <i>S</i>
7.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 <i>A/S</i>
Comment: SECOND CHECK		 <i>S oct 14 201</i>
7.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 <i>A/S</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble and deburr rough edges after tumbling		 <i>A/S</i>
8.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>A.M 09.01.19 200</i>
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>Fix 09/01/21 200</i>
10.0	POWDER COATING 	POWDER COATING <i>1109996</i>
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		
START TIME: <u>9:00AM</u>		
OVEN TEMPERATURE: <u>320°F</u>		
FINISH TIME: <u>9:30AM 9/09/01-22</u>		<i>(200)</i>
11.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		<i>6.m 09.01.22 200</i>
12.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>Bd 1/21 (20)</i>		
13.0	QC21 	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>09/01/26 200</i> <i>MF 09-01-26</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	W16045
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	JF

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

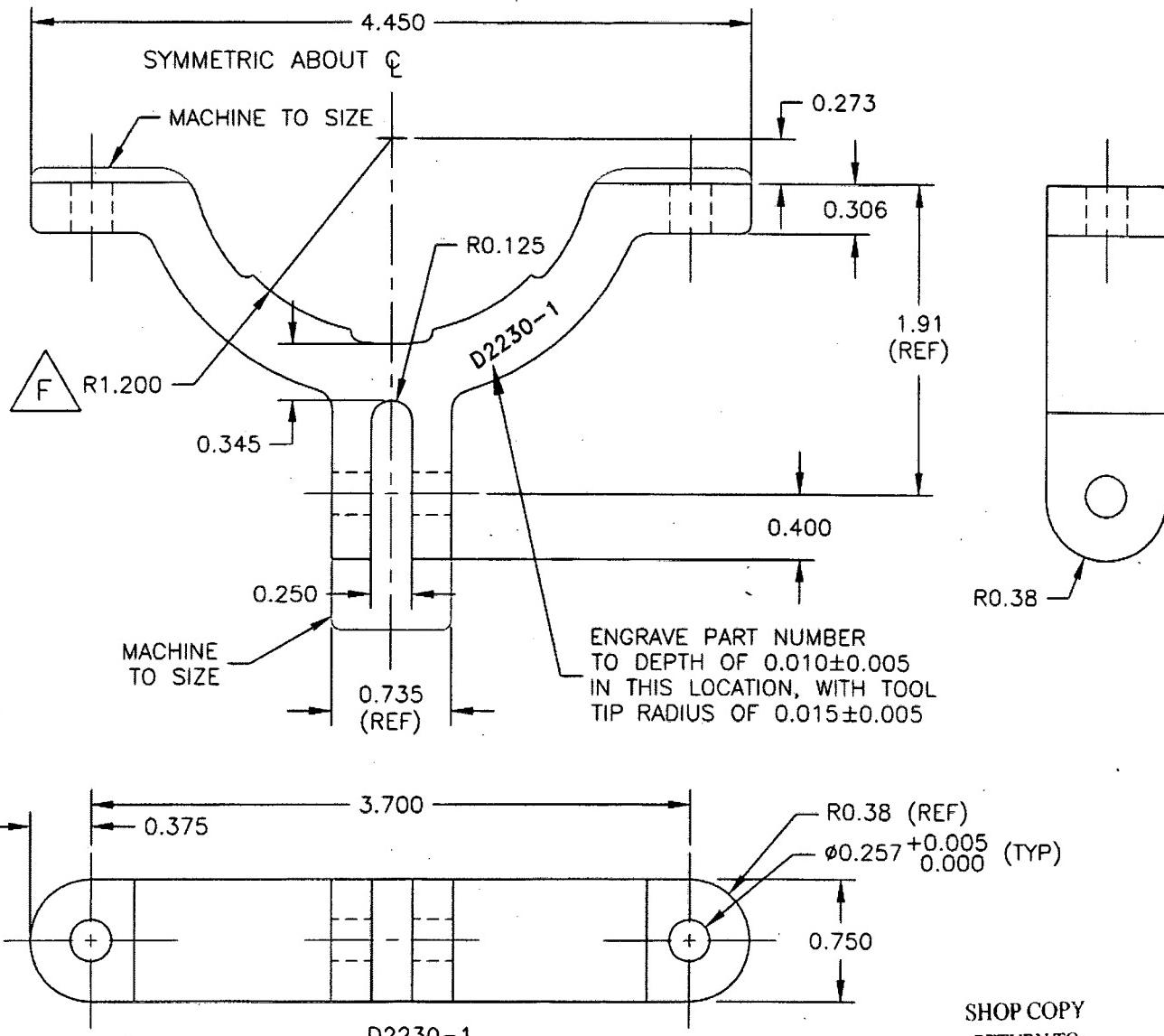
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F
		SHEET 1 OF 2
DATE	TITLE	SCALE
99.12.13	MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

19.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 44025

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

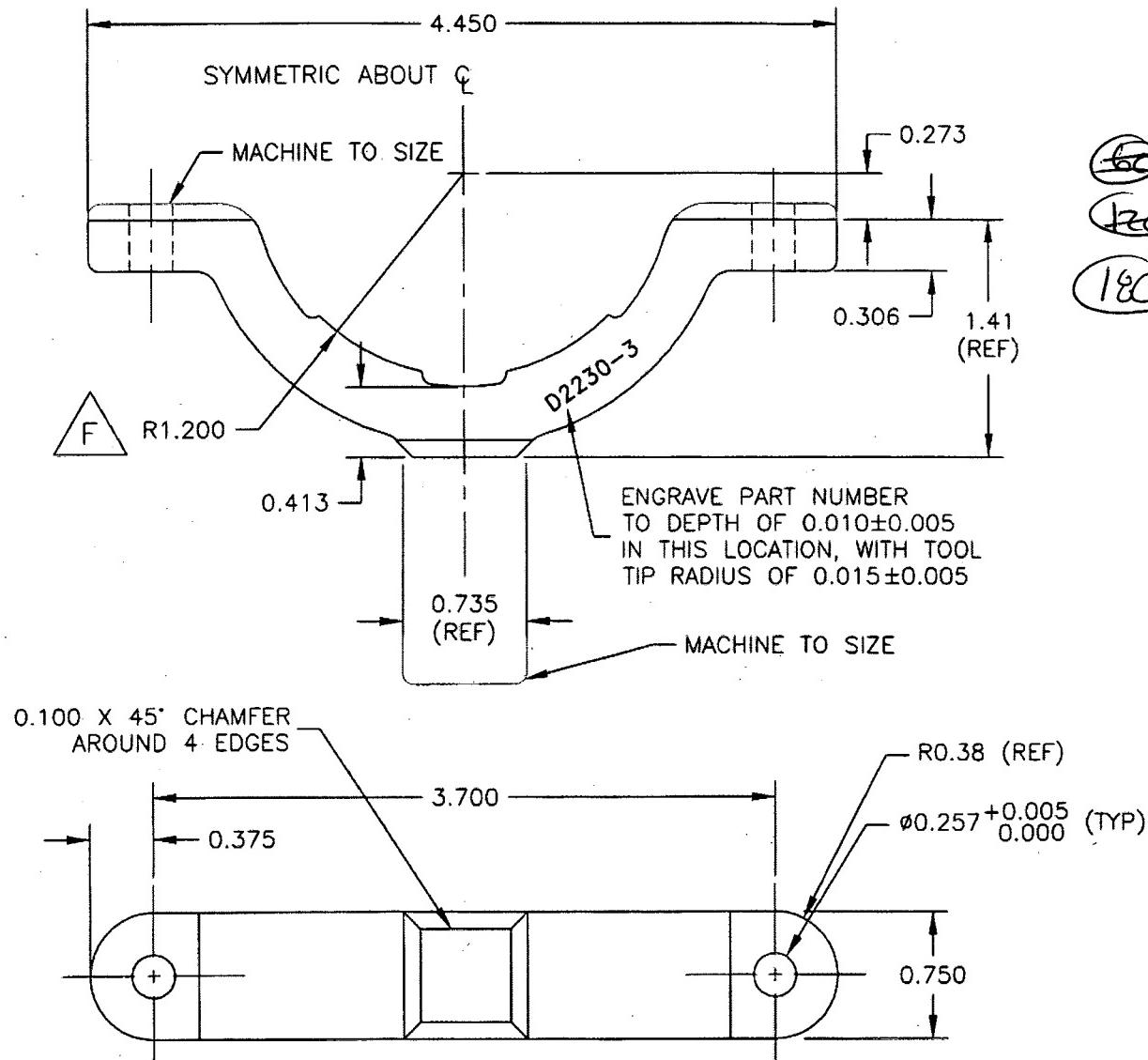
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE		TITLE MOUNTING LUG SCALE 1:1

RELEASED

49.12.21 DS

D2230-3

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44025

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
201	D2230-3	Mounting Lug	7828

MATERIAL supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Walz".
Shig Walz

A handwritten signature in black ink, appearing to read "S. Walz".
S. Walz

Vankleek Hill, January 13, 2009